

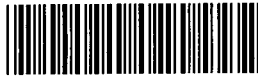
Date: Thursday, 16/10/2008 10:43:04 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET LID ASSEMBLY
 Job Number : 42625B
 Estimate Number : 10207
 P.O. Number :
 This Issue : 16/10/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 41910B
 Part Number : D2989043
 Drawing Number : D2989 REVC
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 31/10/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 08.10.16
 Comment : Est Rev:I Removed D2989-041 05-11-03 JLM
 Est Rev:J 08-08-29 revC as per dwg DD verified by:EC
 Est Rev:K 08-09-24 plug holes prior to powder coating DD
 verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31821 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part number Description Batch
 2 D3182-1 Hinge B 39336

JS 08/11/05

2.0 D34423 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part number Description Batch
 2 D3442-3 Shim B 37160

JS 08/11/05

3.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:



Qty Part number Description Batch
 8sf M304EX0.75-16F Expanded Metal M109383
M108846

JS 08/11/05

4.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SS tubing.



Batch: M108846

JS 08/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/10/2008 10:43:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 42625B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989 ✓

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989 ✓

3-Deburr and remove all markings on material ✓

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required ✓

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

SY 08/11/05

6.0

QC9

VISUAL WELDING INSPECTION



Clog-1-05

2008/11/05



Comment: VISUAL WELDING INSPECTION

7.0

QC6

DIMENSIONAL CHECK



5 08/11/05 @



Comment: DIMENSIONAL CHECK

8.0

POWDER COATING

POWDER COATING



M1109152



(1X)

Comment: POWDER COATING

1- Plug holes in D2989-17 and D2989-2 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15
400 OF
10:45

11:00
400 OF
11:30

M-1 08/11/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/10/2008 10:43:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 42625B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

Soslu @

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12 JJ

mf 08-11-12

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2989-041	BASKET LID ASSEMBLY
	X	D2989-043	BASKET LID ASSEMBLY
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2	2	D2989-17	STRUT
2		D2989-19	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

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WORK ORDER
NO. 42605B

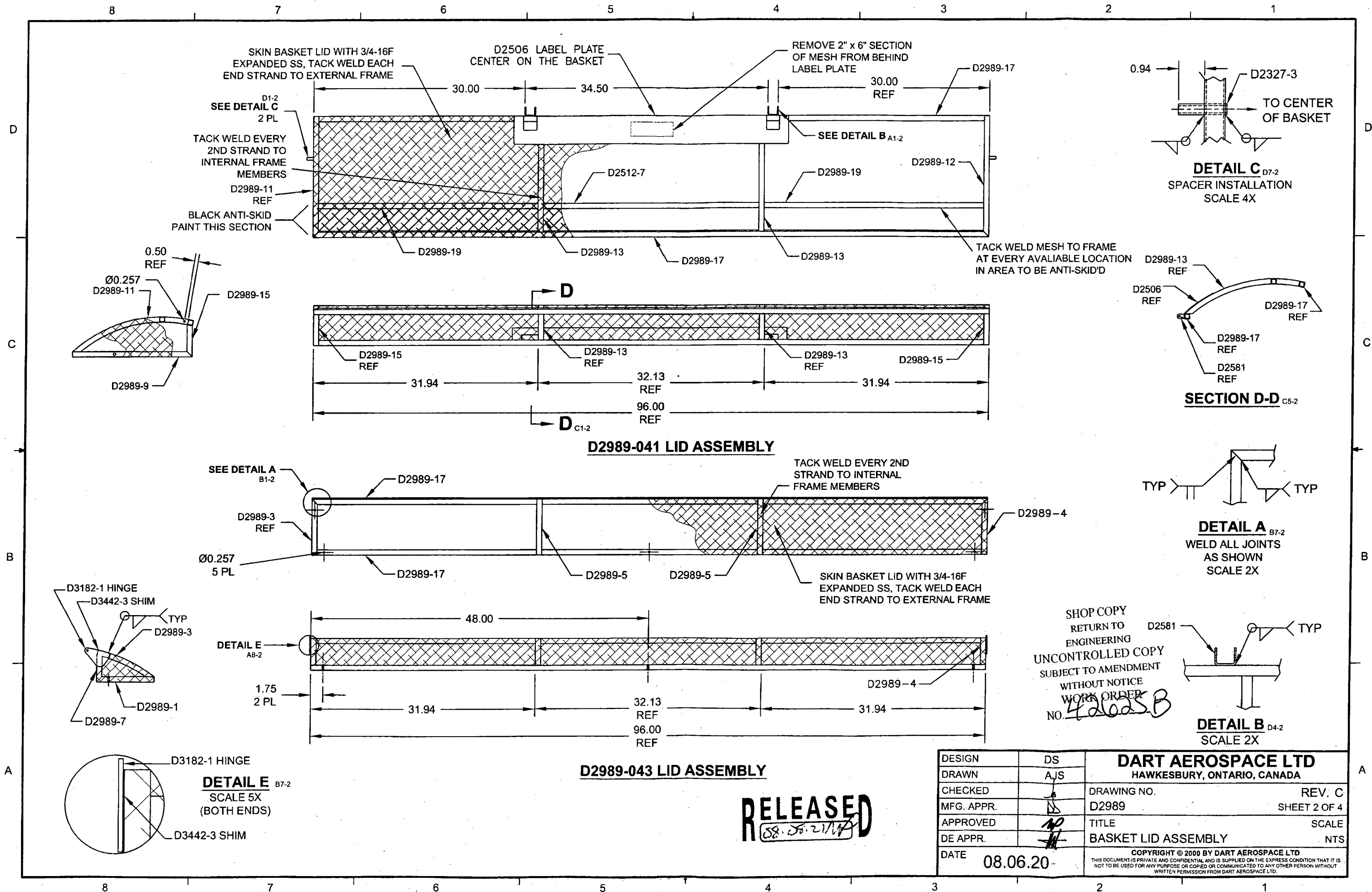
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08-06-20

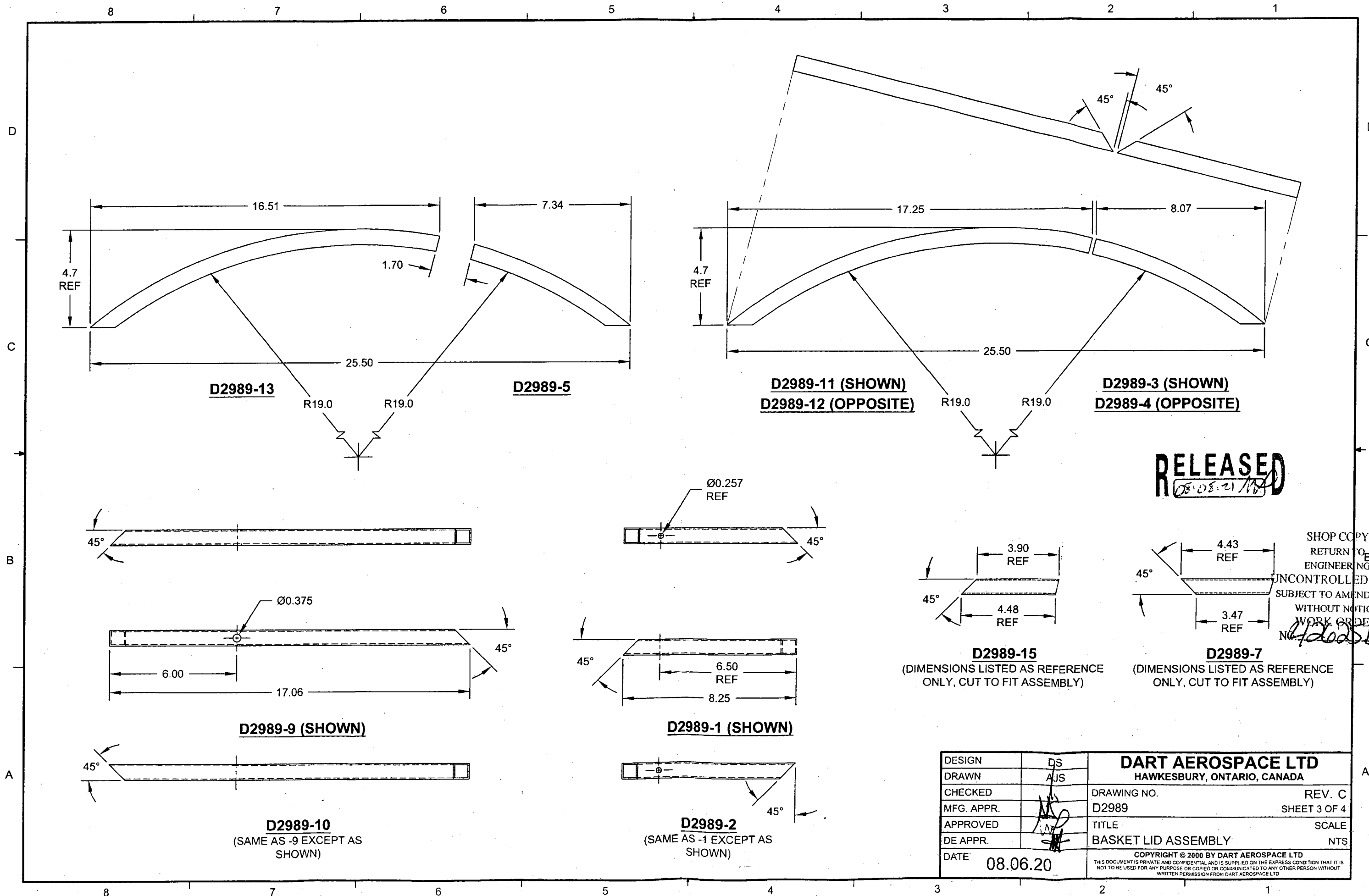


NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

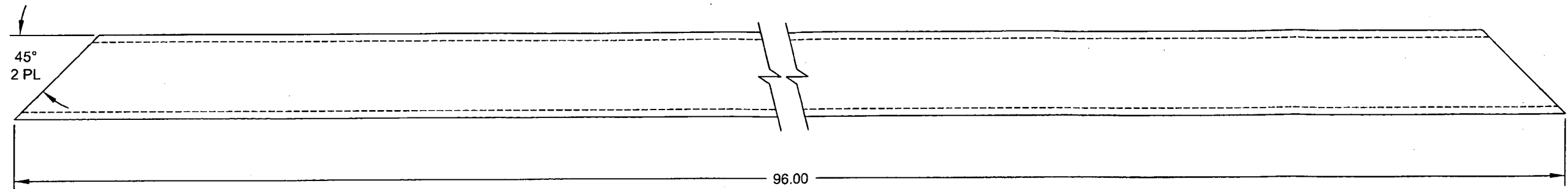
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING TRANSFERED TO "B" SIZE FORMAT & CURRENT DRAFTING STANDARD.	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2989	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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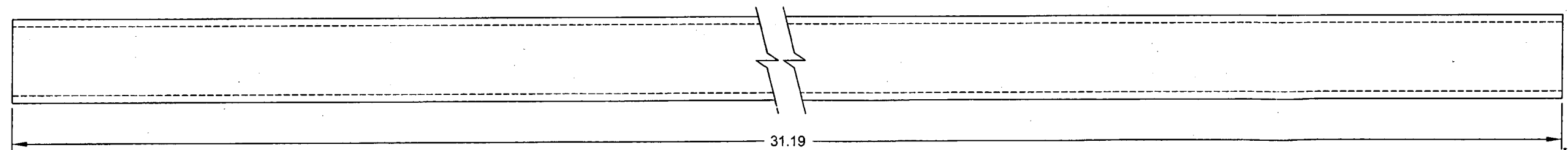
D



D2989-17 STRUT

C

B



D2989-19 STRUT

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WITHOUT NOTICE
WORK ORDER
NO. 421058

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08-08-21/11/11

A

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2989	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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